

Work Order ID 67049

Friday, March 04, 2011 11:23:22 AM



Page 1

Item ID: D412-698-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 3/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-698	Rev E
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100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

Sulosky

HJ for CL 11-3-9

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/3/14 S (12)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulosky

(H)

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-012								
	Location: <u>60</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rec B

11/3/14 SP 10

11/3/15 AJ

ME 11-03-14

Picklist Print

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Work Order ID: 67049

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH



Start Date: 3/4/2011

Required Date: 3/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from
Step 1,3 KJ/DS
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 Bracket Assembly		Manufactured	No			110	Each	6.0000	3	3		11/3/14	
<div>Location</div> <div>ST235A</div> <div>61832</div>													
							Loc Qty	6					
								6					
D3121-144 Bracket Assembly		Manufactured	No			110	Each	5.0000	3	1		11/3/14	
<div>Location</div> <div>ST235A</div> <div>61728</div>													
							Loc Qty	5					
								5					
D3137-043 Bracket Assembly		Manufactured	No			110	Each	5.0000	1	1		11/3/14	
<div>Location</div> <div>ST235B</div> <div>62831</div>													
							Loc Qty	5					
								5					
D3183-044 Bracket Assembly		Manufactured	No			110	Each	5.0000	1	1		11/3/14	
<div>Location</div> <div>ST236</div> <div>61482</div>													
							Loc Qty	5					
								5					

Picklist Print

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Friday, March 04, 2011 11:23:20 AM

Work Order ID: 67049



Parent Item: D412-698-012



Parent Item Name: Cabin Door Roller, RH

Start Date: 3/4/2011

Required Date: 3/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3199-1
Bracket

Manufactured No 110 Each 56.0000

9
11/3/14

Location Loc Qty Loc Code
ST236A 56

61484

56

Manufactured No 110 Each 16.0000

9
11/3/14

D3202-1
Cover

Location Loc Qty Loc Code
ST241A 16

59693

6

66252

10

REFERENCE ONLY

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X	✓					D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01